

Work Order ID 86639

Friday, July 06, 2012 9:10:19 AM

86639

Page 1

Item ID: D3209-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket Assembly

Start Date: 7/6/2012 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 7/11/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: *MF* Date: *12-07-06* Tooling:Run Start ***NR1***

QC: Date: SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3209	Rev A
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100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)

*B.A 12/07/06**10 0*

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3209-1 as per Folio FA345 and Dwg D3209 Identify as D3209-1

Deburr and Tumble

*OK 12/07/08**10*

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*OK 12/07/08**10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

S/R 12-07-09 (X10)

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

10 7/6 12-7-10

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

Note: Cover the hole for D3209-1 before powder coat. START TIME: *11-30* OVEN TEMPERATURE:

FINISH TIME: *12-00*

10x ✓ ML 12/07/10

M121279

3200F

12-00

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4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

161

0.00

161

Small Fab

Memo

0.00

Small Fab

press fit bushing as per dwg

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

10 0 127-10

10

12/07/17

(10)

12/07/17

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Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

180

Identify as per dwg & Stock Location WA

0.00

180

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

102 12/7/188012/7/19MF
12-09-18

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Picklist Print

Friday, July 06, 2012 9:10:18 AM

Page 1

Work Order ID: 86639
Parent Item: D3209-041
Parent Item Name: Bracket Assembly

Start Date: 7/6/2012 Required Date: 7/11/2012
Start Qty: 4.00 Required Qty: 4.00

Comments: IPP A04.06.09New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3209-3 Bushing		Manufactured	No			100	Each	7.0000	1	4			
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Location Loc Qty Loc Code

ST033 7
40930 7

M6061T6B1.500X01.250 6061-T6 Bar 1.50 x 1.25		Purchased	No			170	f	19.3170	0.175	0.7368421			
---	--	-----------	----	--	--	-----	---	---------	-------	-----------	--	--	--

Location Loc Qty Loc Code

MAT003 7.317
118071 0.112
119513 0.945
121660 6.26
MAT004 12
122081 12

(1.5 x 1.5) 120540

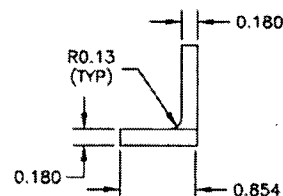
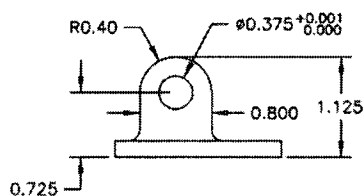
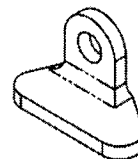
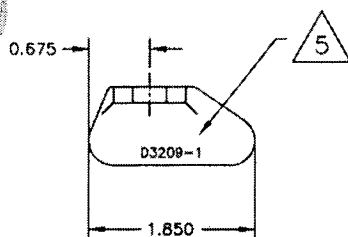
1.675 st

* mat not pulled
from system



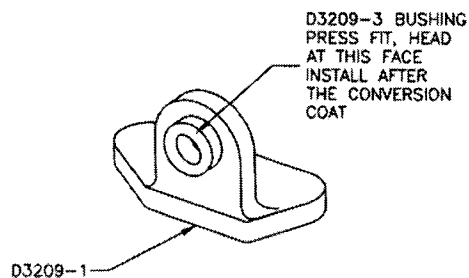
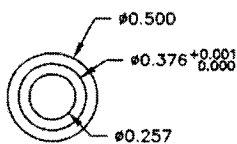
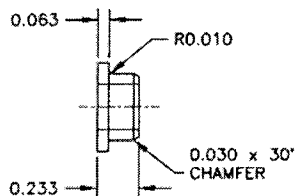
DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05



2

D3209-1 BRACKET



3

**D3209-3 BUSHING
SCALE 1:2**

4

D3209-041 ASSEMBLY

D3209-1 BRACKET: D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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